

**Work Order ID 60927**

Page 1

July 27, 2010 7:01:52 AM

Item ID: D4149-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Plate, Aft

Stop



Start Date: 7/27/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/27/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *V*

Date: \_\_\_\_\_ Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4149	B

100



Waterjet

FLOW CNC Waterjet

304 .16

Memo

0.00

B10-7-27

Cut as per dwg D4149  
Prog Rev: *B*  
Dwg Rev: *B*

Deburr as required

*SB 10/27*

②

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

B10-7-27

Memo

0.00

**Work Order ID 60927**

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July 27, 2010 7:01:52 AM

Item ID: D4149-1

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Setup Start



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Stop



Start Date: 7/27/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/27/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

S10/07/27

150



Packaging

Packaging

Identify as per dwg &amp; Stock Location: GA

B60779

0.00

SA 10/07/27

160



Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/28 AD

10/07/29 AD

# Picklist Print

July 27, 2010 7:01:51 AM

Page 1

Work Order ID: 60927



Parent Item: D4149-1



Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 7/27/10

Required Date: 7/27/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased		No		100	sf	99.4009	0.1355	0.142632	3	VB 10-7-27	

Location	Loc Qty	Loc Code
MAT	99.4009	
114488	1.5259	
114799	97.875	114799

(2)

DART AEROSPACE LTD	Work Order:	60927
Description: CROSS TUBE LUG PLATE ACT	Part Number:	J4149-1
Inspection Dwg: J4149-1 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.129	+ .005 - .001	.130	X		V	FB02
.191	+ .005 - .001	.194	X		V	
.257	+ .006 - .001	.259	X		V	
.38	+ .006 - .001	.379	X		V	
.380	+L .010	.381	X		V	
.469	+L .010	.471	X		V	
.310	+L .010	.311	X		V	
.750	+L .010	.750	X		V	
3.25	+L .030	3.252	S		V	
.65	+L .030	.643	X		V	
.63	+L .030	.624	X		V	
5.46	+L .030	5.456	X		V	
3.80	+L .030	3.801	X		V	
2.13	+L .030	2.122	X		V	
1.313	+L .010	1.311	X		V	
.625	+L .010	.622	X		V	
.375	+L .010	.377	X		V	
1.175	+L .010	1.174	X		V	
.752	+L .010	.746	X		V	
1.588	+L .010	1.583	X		V	
1.587	+L .010	1.586	X		V	
11.15	+L .020	11.158	S		V	RWJ02 Prod-W5-02
.750	+L .010	.759	S		V	

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	10-7-27	Date:	10/07/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	60927
Description: CROSTUBB LUG PLATE AFT	Part Number:	D4149-1
Inspection Dwg:D4149-1 Rev: B		Page 1 of 1

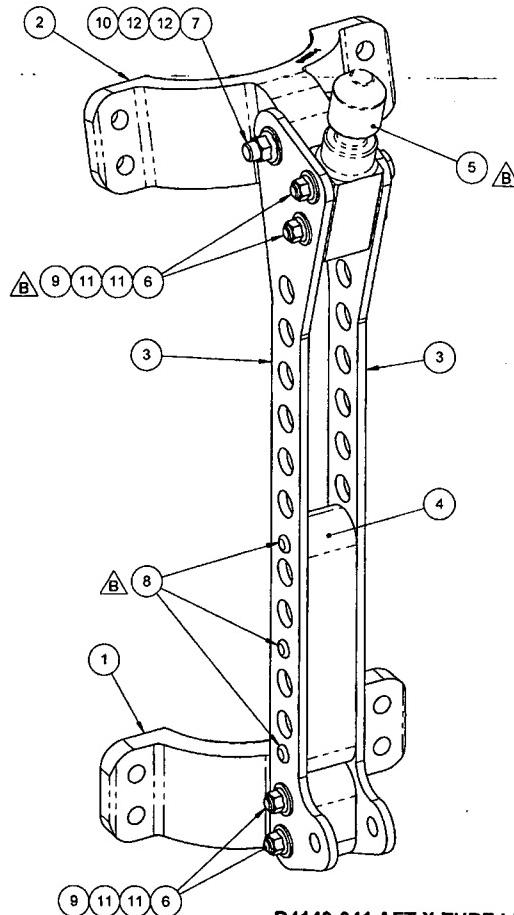
## **FIRST ARTICLE INSPECTION CHECKLIST**

X First Article Prototype

Measured by:	HR	Audited by:	S	Prototype Approval:	N/A
Date:	10-7-27	Date:	10/03/27	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	

ITEM	QTY	P/N	DESCRIPTION
X	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	4	AN3C12A	
7	1	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	4	MS21043-3	NUT
10	1	MS21043-4	NUT
11	8	NAS1149C0332R	WASHER
12	2	NAS1149C0432R	WASHER



**NOTES:**

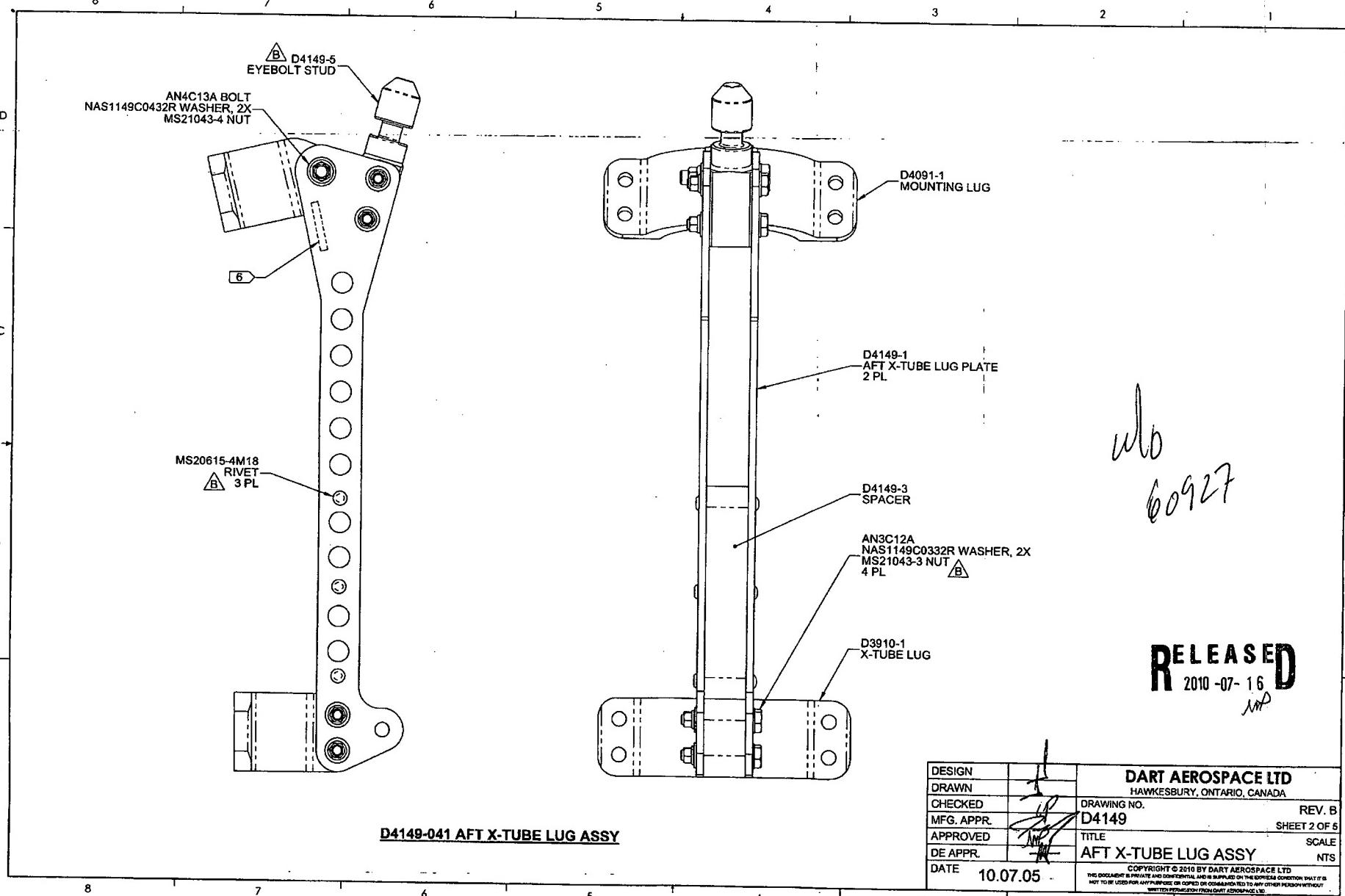
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.17 lbs.

WD 60927

**RELEASED**  
2010-07-16  
*mp*

B		MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø 0.191 2 PL REPLACES Ø 0.191 3 PL (ZN D8-3); REASON: SEE TR-D390-507-2 REV. B.	MB	10.07.05
A		NEW ISSUE	MB	10.06.18
REV.		DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN		REV. B		
CHECKED		DRAWING NO. <b>D4149</b> SHEET 1 OF 5		
MFG. APPR.		TITLE <b>AFT X-TUBE LUG ASSY</b> SCALE NTS		
APPROVED		DATE <b>10.07.05</b>		
DE APPR.				

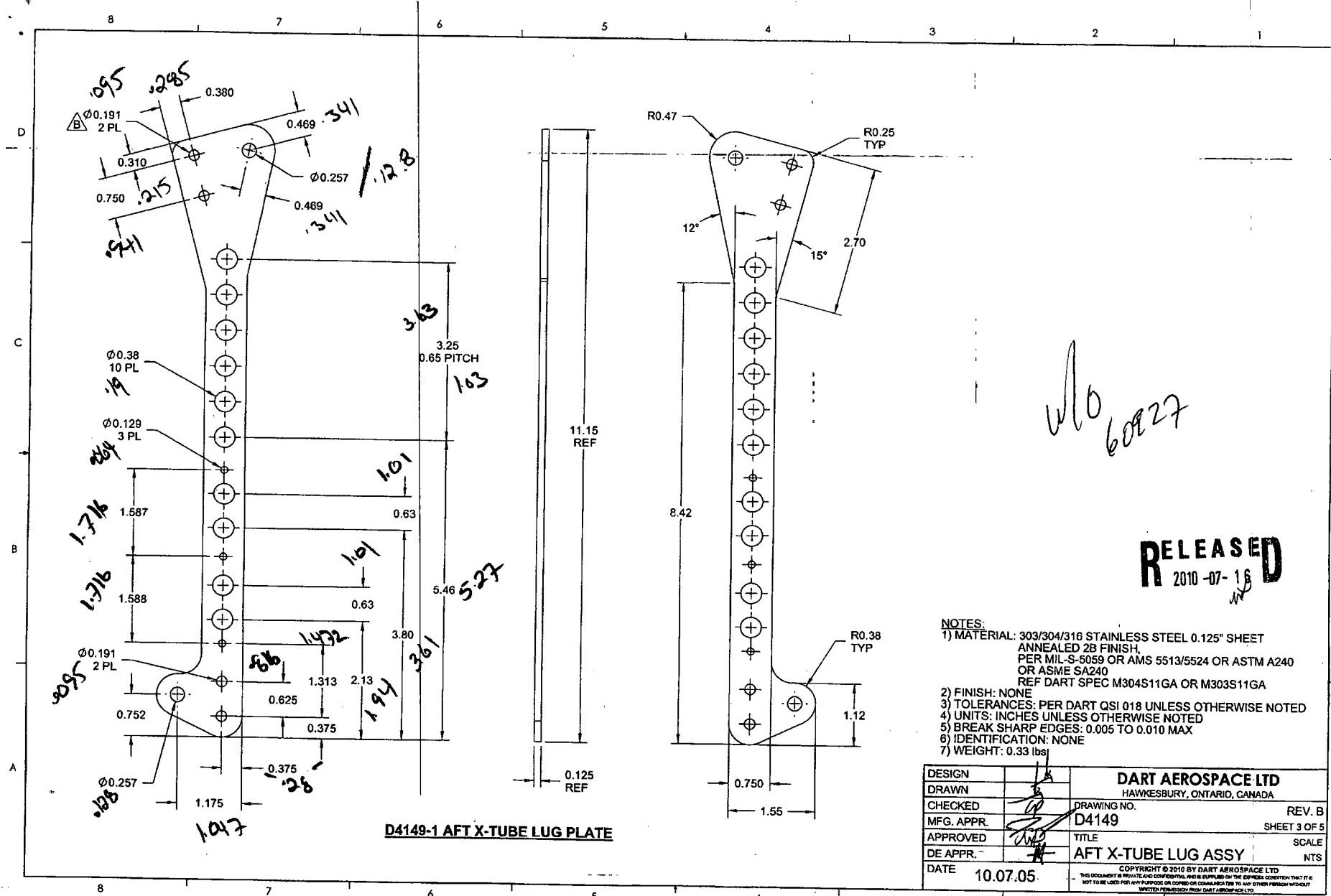
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RELEASED  
2010-07-16  
MD

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D4149
APPROVED		SHEET 2 OF 5
DE APPR.		TITLE
DATE	10.07.05	SCALE
		NTS

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2010-07-16

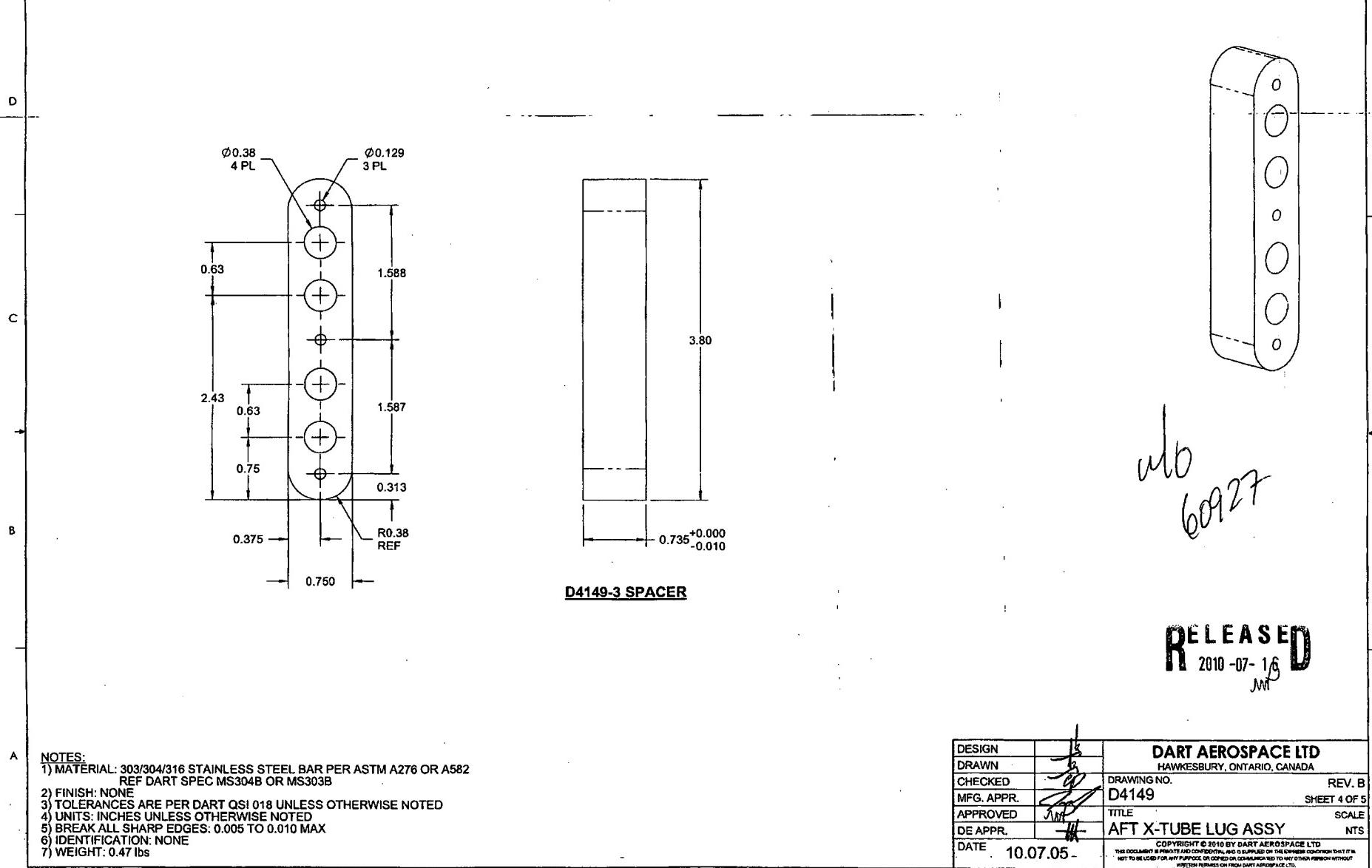
**NOTE:**

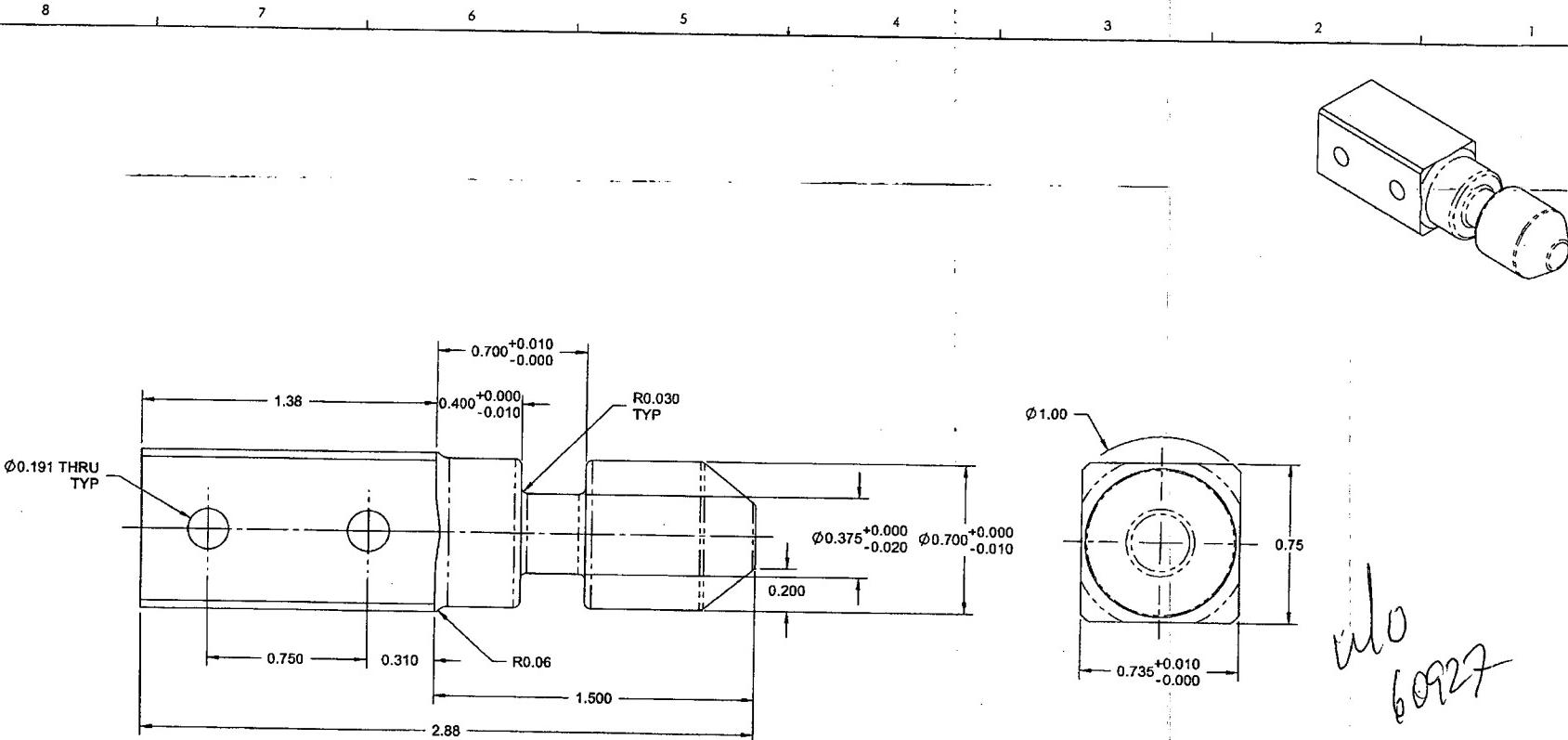
- 1) MATERIAL: 303/304L15 STAINLESS STEEL 0.125" SHEET  
ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240  
OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: .0005 TO .010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.33 lbs.

DESIGN	<i>JK</i>	DART AEROSPACE LTD
DRAWN	<i>JK</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>JP</i>	DRAWING NO.
MFG. APPR.	<i>SJW</i>	D4149
APPROVED	<i>JWZ</i>	TITLE
DE APPR.	<i>JK</i>	AFT X-TUBE LUG ASSY
DATE	10.07.05	REV. E SHEET 3 OF 3 SCALE NTS

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8 7 6 5 4 3 2 1





**D4149-5 EYEBOLT STUD**

**RELEASED**  
2010-07-16  
*[Handwritten signature]*

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582  
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.33 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D4149
APPROVED	<i>[Signature]</i>	REV. B
DE APPR.	<i>[Signature]</i>	SHEET 5 OF 5
DATE	10.07.05	TITLE
		SCALE
		NTS

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